

slp Thursday 19/04
83443

Work Order ID 83443

April-18-12 8:08:31 AM

Page 1

Item ID: D4420-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Top Support Assembly

Start Date: 4/18/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/18/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4420

B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut D4420-1 as per dwg

prog rev: 8

dwg rev: 3

2- Deburr as per dwg

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-4-18

3

B12-4-18

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Page 2

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Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

125

Bend as per dwg

0.00

125

Brake NC

Memo

0.00

Brake NC

127

QC6- Inspect dimensions to drawing

0.00

127

QC

Memo

0.00

Quality Control

8/7/12

(73)

(3)

8/12/12

(73)

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Reference:

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Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

Chemical Conversion Coat per QS1005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

3 HG 12-4-18

131

QC7-Inspect Chemical Conversion Coat

0.00

131

QC

Memo

0.00

Quality Control

3X 12/04/18

133

0.00

133

Small Fab

Memo

0.00

Small Fab

ONLY Install D4006-3 to D4420-1

3X 12/04/18

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Cust Item ID:

Required Date: 4/18/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

136

QC5- Inspect part completeness to step on W/O

0.00

136

QC

Memo

0.00

Quality Control

139

Gloss Grey (4.3.5.15) per QSI 005 4.3

0.00

139

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

Scrubbers

(X3)

M 118533

*10-10-10
3200 F
10-30*

3X

*M-L
12/24/18*

34

12/4/19

Work Order ID 83443

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Accept

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Stop ***NS2***

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Start Date: 4/18/12 Start Qty: 2.00

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Cust Item ID:

Required Date: 4/18/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00

150

Small Fab

Memo

0.00

Small Fab

Assemble anchornut and foam as per dwg D4420

3x Ø 4/20/19

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

(3)

SB 12/04/19

190

Identify as per dwg & Stock Location: 139A

0.00

190

Packaging

Memo

0.00

Packaging

4/14/15 (3)

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Start Date: 4/18/12 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 4/18/12 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/4/19

MF

120411

Picklist Print

April-18-12 8:08:30 AM

Page 1

Work Order ID: 83443

Parent Item: D4420-041

Parent Item Name: Top Support Assembly

Start Date: 4/18/12

Required Date: 4/18/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM
DWG REV.B DD VERF:EC

IPP REV:B 12.03.01 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-3 Channel		Manufactured	No			133	Each	17.0000	1	2		4/12/04/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		17							
				80627		17							
D4006-5 Foam		Manufactured	No			150	Each	13.0000	1	2		4/12/04/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST082		13							
				80023		13							
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	399.9000	0.3	0.6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		399.9							
				119916		159.9							
				121197		240							
MS20426AD3-4 RIVET		Purchased	No			150	Each	3,280.0000	2	4		4/12/04/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		3280							
				104374		614							
				110398		2666							
MS20470AD4-5 Rivet, Universal Head		Purchased	No			133	Each	2,103.0000	4	8		4/12/04/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		2103							
				118405		744							
				120142		1359							

3
12.04.19
051042.

13 12-4-19

(3)

119916

4/12/04/19
M121011 (6X)

12

Picklist Print

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Page 2

Work Order ID: 83443

Parent Item: D4420-041

Parent Item Name: Top Support Assembly

Start Date: 4/18/12

Required Date: 4/18/12

Start Qty: 2.00

Required Qty: 2.00

MS21059L4

Purchased

No

150

Each

70.0000

1

Nutplate

2
EPB 12/04/19

Location

Loc Qty

Loc Code

ST301

8

117887

3

119623

5

ST302

62

120930

12

121060

50

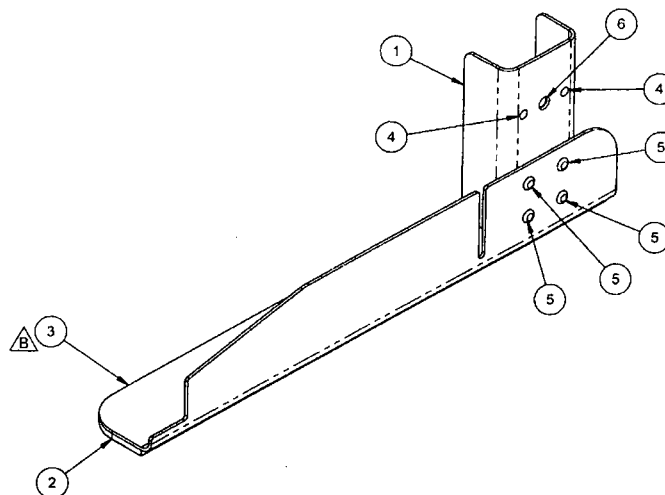
3

April-18-12 8:08:30 AM

Shop Packet Print

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4420-041	TOP SUPPORT ASSY
1	1	D4006-3	CHANNEL
2	1	D4006-5	FOAM
3	1	D4420-1	ANGLE
4	2	MS20426AD3-4	RIVET
5	4	MS20470AD4-5	RIVET
6	1	MS21059L4	ANCHOR NUT



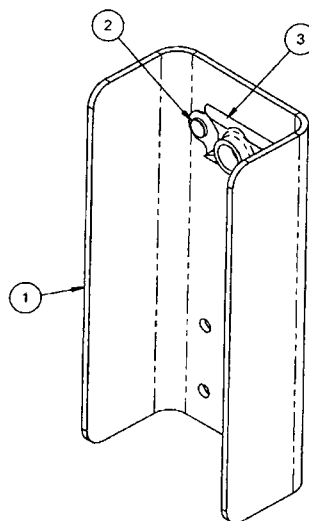
D4420-041 TOP SUPPORT ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4420-041" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.38 lbs

B	ADD RELIEFS FOR COMPATIBILITY WITH EUROCOPTER SQUIRREL CHEEK, FINISH WAS "GREY SANDING" (4.3.5.6)	MB	12.02.21
A	NEW ISSUE	MB	11.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D4420	SHEET 1 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		TOP SUPPORT ASSY	NTS
DE APPR.		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHEN SUPPLIED ON THE BASIS OF CONFIDENTIALITY IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	12.02.21		

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4420-043	TOP LEG SUPPORT ASSY
1	1	D4006-3	CHANNEL
2	2	MS20426AD3-4	RIVET
3	1	MS21059L4	ANCHOR NUT



D4420-043 TOP LEG SUPPORT ASSY

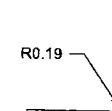
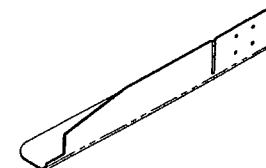
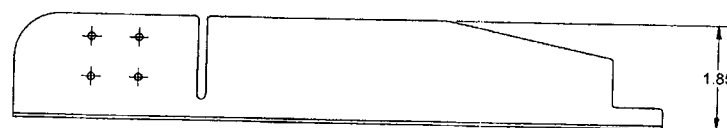
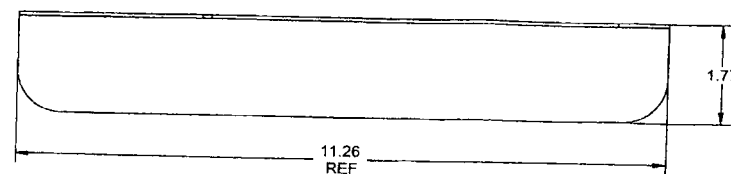
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 BEFORE INSTALLATION OF MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4420-043" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs



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RELEASED
2012-03-09



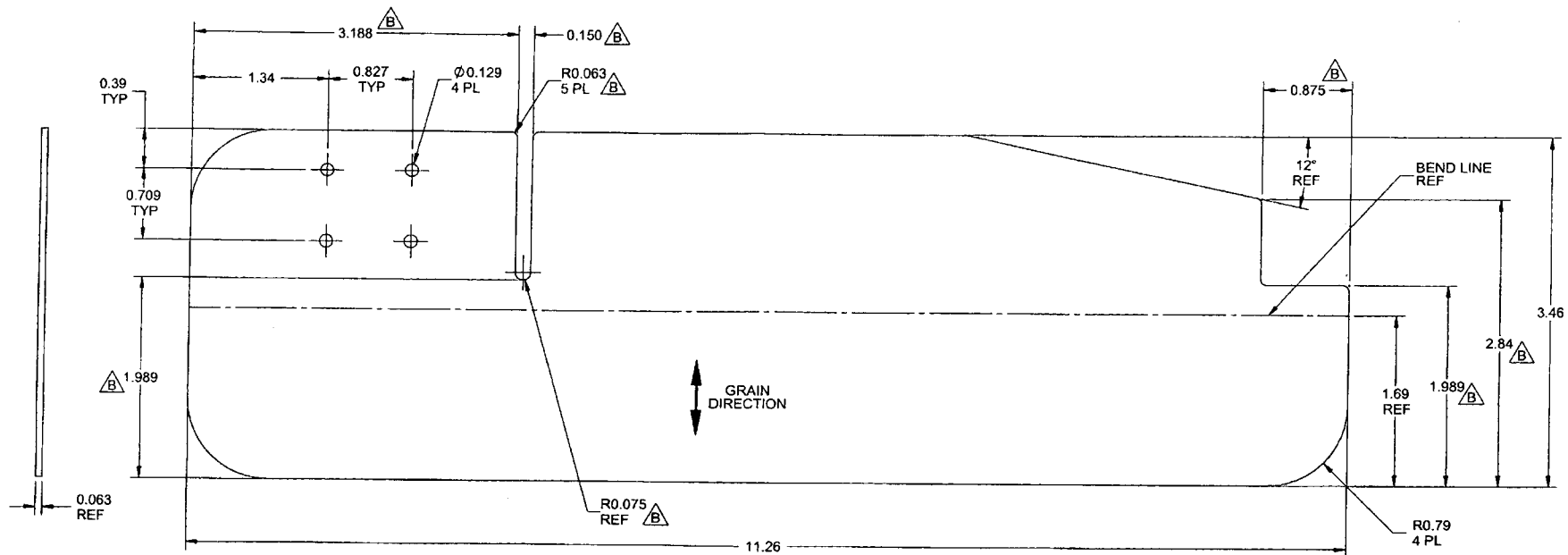
D4420-1 ANGLE

RELEASE
2012-03-02

NOTES:

- 1) MATERIAL: MADE FROM D4420-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

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MFG. APPR.		D4420	SHEET 3 OF 4
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D4420-1F FLAT PATTERN

RELEASED
2012-03-03
JMB

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4420
MFG. APPR.		REV. B SHEET 4 OF 4
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